

PAROBY
SOL
Work Order ID 63679

November 10, 2010 8:49:25 AM

Page 1

Item ID: D429-793-011

Accept



Setup Start



Revision ID:

Item Name: Bearpaw Installation

Stop



Start Date: 11/10/10 Start Qty: 5.00



Cust Item ID:

Required Date: 11/15/10 Req'd Qty: 5.00



Customer:

Reference:

Approvals: Process Plan:

✓

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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IIN-D429-793

B

100



DOCUMENT CONTROL

DC

Document Control

Memo

0.00

0.00

Photocopy bluefile and create labels per PPP D429-793-011 CHG 001

11/10/11 26
Sol 16/25

110



Pick Kit

0.00

0.00

Packaging

Packaging

Memo

0.00

R 11/11/20 *(S)*

120



QC4- 100% Inspect kits for completeness

0.00

0.00

QC

Quality Control

Memo

0.00

Sol 16/25

X5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 63679



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Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

130

Operation
Description

Packaging

Set Up/
Run Hours

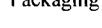
Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

Packaging



Memo

0.00

Identify and pack for shipping as per PPP D429-793-011
Location:

FG14 MVA

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

MF
10-11-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

November 10, 2010 8:49:23 AM

Page 1 / 3

Work Order ID: 63679



Parent Item: D429-793-011



Parent Item Name: Bearpaw Installation

Start Date: 11/10/10

Required Date: 11/15/10

Start Qty: 5.00

Required Qty: 5.00

Comments: Rev. A New Issue 10/10/18 DL
Change AN4C12A bolts to AN4C13A bolts 10/11/05 DL

IPP Rev. B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN4C13A 		Purchased		No		110	Each	58.0000	8	40			

Location	Loc Qty	Loc Code
ST357	58	
113359	3	
114442	5	
114615	50	

AN4C15A 	Purchased	No	110	Each	199.0000	4
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Location	Loc Qty	Loc Code
ST358	199	
115835	99	
115936	100	

D2274 	Manufactured	No	110	Each	397.0000	12
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Location	Loc Qty	Loc Code
ST010	397	
59108	4	
61361	78	
62658	315	

D3980-041 	Manufactured	No	110	Each	0.0000	2
---------------	--------------	----	-----	------	--------	---

Bearpaw Assembly

63681 11/11/20

5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November 10, 2010 8:49:23 AM

Page 2 *B*

Work Order ID: 63679



Parent Item: D429-793-011



Parent Item Name: Bearpaw Installation

Start Date: 11/10/10

Required Date: 11/15/10

Start Qty: 5.00

Required Qty: 5.00

D4176-1



429 Clamp, Top

Manufactured

No

110

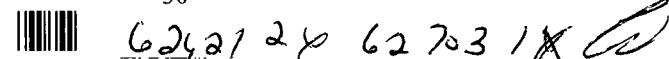
Each

0.0000

6

30

63683 27



D4176-3



429 Clamp, Bottom

Manufactured

No

110

Each

0.0000

2

10

B62421 28



D4211-041



Wearplate

Manufactured

No

110

Each

0.0000

2

10

63686

✓

D4212-1



429 Clamp Cushion

Manufactured

No

110

Each

0.0000

6

30

63687

MS21043-4



Nut

Purchased

No

110

Each

822.0000

12

60

✓ 10/11/25 ⑤

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	40	
104603	40	
ST301	782	
112492	25	
113069	8	
114523	149	
114784	300	
115936	300	

1114784

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November 10, 2010 8:49:23 AM

Page 3 *13*

Work Order ID: 63679



Parent Item: D429-793-011

Parent Item Name: Bearpaw Installation

NAS1149D0463J

Purchased

No

110

Each

1,857.000

24

120



Start Date: 11/10/10

Required Date: 11/15/10

Start Qty: 5.00

Required Qty: 5.00



<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST298	1857	
10096	10	
114576	68	
115622	45	
116025	1734	

10/10/2010

10/10/2010

10/10/2010

10/10/2010

10/10/2010

10/10/2010

10/10/2010

10/10/2010

10/10/2010

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

3.0 INSTALLATION PROCEDURE

- 3.1 Jack up the aircraft.
- 3.2 Skid wearplates and/or wear pads may be removed in the area of the Ultrapaw™. Seal holes using Sikaflex- 241/291 or Proseal 890 or MIL-S-8802 Class 2B sealant. Ensure skid is serviceable and free from wear and/or damage.
- 3.3 If installing the Ultrapaw™ over the wearplates/wear pads, the Ultrapaw™ may be relieved to clear wearplates/wear pads mounting screws provided the relief leaves 0.125" (3.18 mm) minimum thickness.
- 3.4 Install a D3980-041 Ultrapaw™ Assy on the aft end of each skidtube using the D4176-1/-3 Clamps, D4212-1 Clamp Cushion, D4211-041 Wearplate and associated hardware as shown in Figure 2. **CAUTION: The torque on the nuts should be limited to 20 in-lb to allow the Ultrapaw™ to rotate as the landing gear spreads.**
Note: To ease installation, it is recommended to loosely install the two aftmost set of clamps onto the Ultrapaw™ and then slide the Ultrapaw™ over the aft end of the skidtube before installing the fwd clamp.
- 3.5 Although not generally necessary, it is acceptable to use longer or shorter AN4 bolts to ensure 1.5-4 threads in safety on the nuts. Additional NAS1149D0463J washers may also be installed under the nuts.
- 3.6 Lower the aircraft

4.0 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D429-793-011 Ultrapaw™ Installation	21.0 lb 9.5 kg	0.0 in 0.0 m	0.0 lb-in 0.0 m-kg	275.8 in 7.0 m	5792 in-lb 66.5 m-kg

5.0 PARTS LIST

QTY -011	Part Number	Description
X	D429-793-011	ULTRAPAW™ INSTALLATION
12	D2274	RADIUS BLOCK
2	D3980-041	ULTRAPAW™ ASSY
6	D4176-1	CLAMP, TOP
2	D4176-3	CLAMP, BOTTOM
2	D4211-041	WEARPLATE
6	D4212-1	CLAMP CUSHION
8	AN4C13A	BOLT
4	AN4C15A	BOLT
12	MS21043-4	NUT
24	NAS1149D0463J	WASHERS

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Revision: B
Date: 10.10.25

FRI DAY

Work Order ID 63679

November 10, 2010 8:49:25 AM

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Accept



Page 1

Setup Start



Stop



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Customer:

Reference:

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✓

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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IIN-D429-793	B
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100



DOCUMENT CONTROL

DC
Document Control

Memo

0.00

0.00

Photocopy bluefile and create labels per PPP D429-793-011 CHG 001

11/10/11 2:00

Solnbs

110



Pick Kit

0.00

Packaging
Packaging

Memo

0.00

11/10/11 2:00

120



QC4- 100% Inspect kits for completeness

0.00

QC
Quality Control

Memo

0.00

Solnbs

X5

11/10/11 2:00

PTO

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
11/02/09	120	Boxes were opened, new stickers were applied then contents were verified and boxes repacked.	John	11/02/09	4	11-02-09		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

130



Packaging

Operation
Description

Packaging

Set Up/
Run Hours

0.00

Tool ID

Date:

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Memo
Identify and pack for shipping as per PPP D429-793-011
Location:

FG14 MVA

11-01-04

FG 14

11/11/25 (5)

11/11/26

MF
10-11-25DR
11/02/09